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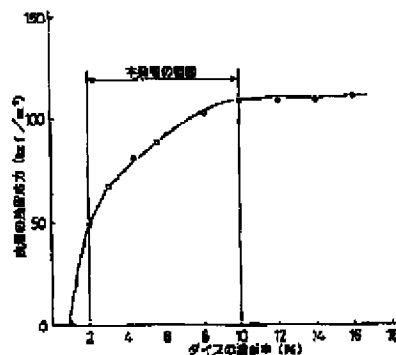
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(54) **MANUFACTURE OF BRASS PLATED STEEL WIRE**

(57) Abstract:

PURPOSE: To provide a method for manufacturing a hard wire for reinforcing rubber articles to which especially fatigue property, adhesion to rubber and corrosion resistance are required.

CONSTITUTION: In a 1st stage to a 4th stage, including the final stage, on the upstream side from the final stage of a wire drawing process, air projecting type shot peening treatment using compressed air is applied to a brass plated steel wire whose diameter is 1-0.4mm and tensile strength is $\approx 300 \text{ kgf/mm}^2$ and which is manufactured by executing wire drawing with a skin-pass die of 2-10% reduction of area under conditions that shot grain size: $\leq 200 \mu\text{m}$, HV hardness of the shot grain: ≈ 500 and $\text{Sp} = 2-100 \text{ kgf/cm}^2 \cdot \text{sec}$ ($\text{Sp} = \text{air jetting pressure (kgf/cm}^2) \times \text{shot peening treating time (sec)}$).



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